AMENDMENTS TO THE CLAIMS WITH MARKINGS TO SHOW CHANGES MADE, AND LISTING OF ALL CLAIMS WITH PROPER IDENTIFIERS

1.-19. (Canceled)

20. (Currently amended) A metallic tube portion for a tube coil, comprising a single-piece centrifugally cast tube defined by a longitudinal axis having at least two tube bends in which an orientation of the longitudinal axis of the tube portion changes continuously, and an intermediate region between the tube bends in which an orientation of the longitudinal axis remains unchanged, wherein the tube is made of a DIN EN 10027 part 1 material selected from the group consisting of GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4, GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.

21. (Previously presented) The tube portion as claimed in claim 20, wherein the tube has opposite ends and includes individual subsections between the ends, wherein the subsections define a longitudinal axis which extends in more than one plane between the ends of the tube.

22. (Previously presented) The tube portion as claimed in claim 20, wherein the tube bends are each defined by a bending radius and a tube diameter at a ratio of bending radius to tube diameter of a tube bend which ratio, at least in sections, is less than 1.5.

23. (Previously presented) The tube portion as claimed in claim 22, wherein the ratio of bending radius to tube diameter, at least in sections, is less than 1.1.

24. (Previously presented) The tube portion as claimed in claim 20, wherein the tube bends are spaced by an intermediate length of less than 300 mm.

25. (Previously presented) The tube portion as claimed in claim 24, wherein the intermediate length between the tube bends is less than or equal to 40 mm.

26. (Previously presented) The tube portion as claimed in claim 20, wherein the tube has a substantially constant wall thickness.

27. (Previously presented) The tube portion as claimed in claim 26, wherein the wall thickness of the tube is between 6 mm and 14 mm.

28. (Previously presented) The tube portion as claimed in claim 20, wherein the tube has an inner surface which, at least in sections, has a roughness of less than 12 R_a.

29. (Previously presented) The tube portion as claimed in claim 28 wherein the inner surface of the tube, at least in sections, has a roughness of less than 3.2 R_a.

30. (Currently amended) A tube coil for a chemical plant, comprising plural tubes; and at least one tube portion defined by a longitudinal axis and connected to one end of one of the tubes, said tube portion including a single-piece centrifugally cast tube having at least two tube bends in which an orientation of the longitudinal axis of the tube portion changes continuously, and an intermediate region between the tube bends in which an orientation of the longitudinal axis remains unchanged, wherein the tube is made of a DIN EN 10027 part 1 material selected from the group consisting of GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4,

GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.

31. (Previously presented) The tube coil as claimed in claim 30, wherein the tube portion, at least at one of the ends, is connected to a tube or tube portions produced from a same material.

32. (Currently amended - Withdrawn) A process for producing a tube portion, comprising the step of making the tube portion from a centrifugally cast tube, said tube portion defined by a longitudinal axis having at least two tube bends in which an orientation of the longitudinal axis of the tube portion changes continuously, and an intermediate region between the tube bends in which an orientation of the longitudinal axis remains unchanged, wherein the tube is made of a DIN EN 10027 part 1 material selected from the group consisting of GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4, GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.

33. (Withdrawn) The process as claimed in claim 32, further comprising the step of shaping the centrifugally cast tube by inductive bending.

34. (Withdrawn) The process as claimed in claim 33, further comprising the step of heat treating the centrifugally cast tube prior to the inductive bending step .

35. (Withdrawn) The process as claimed in claim 34, further comprising the step of heat treating the centrifugally cast tube at a temperature of 800°C to 1200°C prior to the inductive bending step.

36. (Withdrawn) A process for producing a tube coil, comprising the step of making a tube portion from a centrifugally cast tube.

37. (Withdrawn) The process as claimed in claim 36, further comprising the step of shaping the centrifugally cast tube by inductive bending.

38. (Withdrawn) The process as claimed in claim 37, further comprising the step of heat treating the centrifugally cast tube prior to the inductive bending step .

39. (Withdrawn) The process as claimed in claim 38, further comprising the step of heat treating the centrifugally cast tube at a temperature of 800°C to 1200°C prior to the inductive bending step.

40. (Currently amended) Fitting substitute for a tube coil with fittings, comprising a metallic tube portion defined by a longitudinal axis and including a single-piece centrifugally cast tube having at least two tube bends in which an orientation of the longitudinal axis of the tube portion changes continuously, and an intermediate region between the tube bends in which an orientation of the longitudinal axis remains unchanged, wherein the tube is made of a DIN EN 10027 part 1 material selected from the group consisting of GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4, GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.

41. (Currently amended) Cracker with a metallic tube portion defined by a longitudinal axis and including a single-piece centrifugally cast tube having at least two tube bends in which an orientation of the longitudinal axis of the tube portion changes continuously, and an intermediate region between the

tube bends in which an orientation of the longitudinal axis remains unchanged, wherein the tube is made of a DIN EN 10027 part 1 material selected from the group consisting of GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4, GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.

42. (Currently amended) Cracker with a tube coil having plural tubes; and at least one tube portion defined by a longitudinal axis and connected to one end of one of the tubes, said tube portion including a single-piece centrifugally cast tube having at least two tube bends in which an orientation of the longitudinal axis of the tube portion changes continuously, and an intermediate region between the tube bends in which an orientation of the longitudinal axis remains unchanged, wherein the tube is made of a DIN EN 10027 part 1 material selected from the group consisting of GX40CrNiSi25-20, GX40NiCrSiNb35-25, GX45NiCrSiNbTi35-25, GX35CrNiSiNb24-24, GX45NiCrSi35-25, GX43NiCrWSi35-25-4, GX10NiCrNb32-20, GX50CrNiSi30-30, G-NiCr28W, G-NiCrCoW, GX45NiCrSiNb45-35, GX13NiCrNb45-35, GX13NiCrNb37-25, GX55NiCrWZr33-30-04.

43. (Previously presented) The tube portion as claimed in claim 22, wherein the ratio of bending radius to tube diameter, at least in sections, is less than or equal to 1.04.